

301 ~~220.249~~ 314
Work Order ID 161642

161642

Page 1

Friday, May 19, 2017 11:36:40 AM

Item ID: D3589-23 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Arm Guide
 Start Date: 5/23/2017 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 5/25/2017 Req'd Qty: 12.00 ***12*** Customer:
 Reference: (P.A.)SCHEDULED/S

Approvals: Process Plan: PA ^{DAS} 21 ₉₋₈₉ Date: 2017/05/23 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3589	C

100 0.00

100

Hardinge Memo 1.44
 Hardinge CNC Lathe Small 1-TURN AS PER FOLIO FA**** & DWG D3589
 FOLIO REV: AA
 DWG REV: C

2-DEBURR AS REQUIRED

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110

QC Memo 0.12
 Quality Control

12 0 ^{DAS} 45 ₉₋₈₉
 2017-5-29

12 0 ^{DAS} 45 ₉₋₈₉
 2017-5-29

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Work Order ID 161642

161642

Page 2

Friday, May 19, 2017 11:36:40 AM

Item ID: D3589-23 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Arm Guide
 Start Date: 5/23/2017 Start Qty: 12.00 *12* Cust Item ID:
 Required Date: 5/25/2017 Req'd Qty: 12.00 *12* Customer:
 Reference: (P.A.)SCHEDULED/S

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.24				12	0		DAS 08 9-89
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo LOCATION: WA002	0.00 0.12				12			DAS 6 9-89 MAY 31 2017
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 1.20							17/6/2

DAS
21
9-89

MAY 31 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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2712

Picklist Print

Friday, May 19, 2017 11:36:39 AM

Page 1

Work Order ID: 161642

161642

Parent Item: D3589-23

D3589-23

Parent Item Name: Arm Guide

Start Date: 5/23/2017

Required Date: 5/25/2017

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A 12.07.23 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304RO.750		Purchased	No			100	f	35.2920	0.0542	0.6504			

M304RO 750

304 SS Roundbar .750

**

Location

Loc Qty

Loc Code

MAT

0.583

M135512

0.583

MAT029

34.709

M137175

10.709

M137400

24

0.875

DAS
45
9-89

20125-29

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

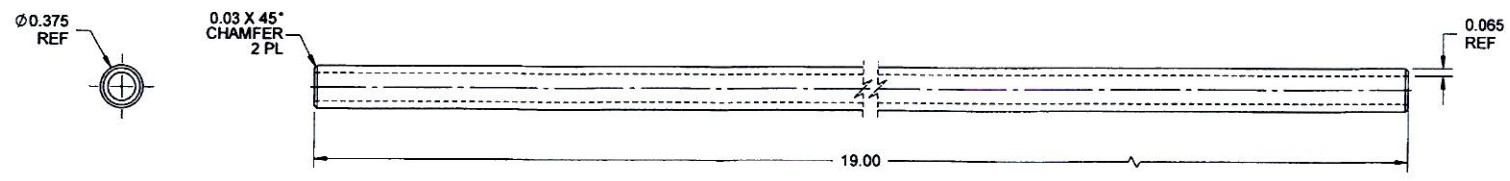


QA Closed: _____ Date: _____

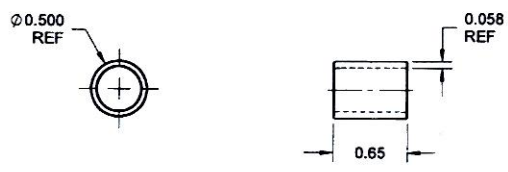
Work Order update only ☐

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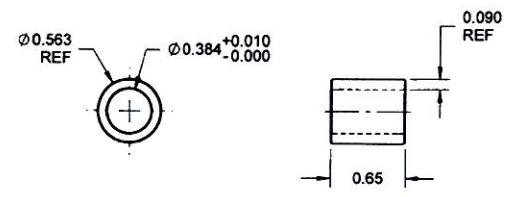
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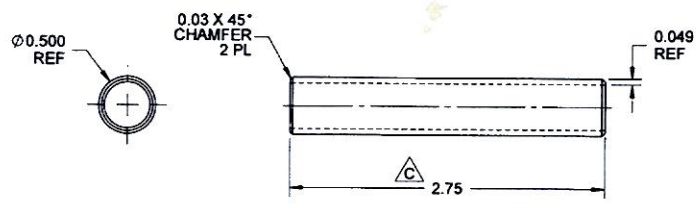
D3589-1 ARM



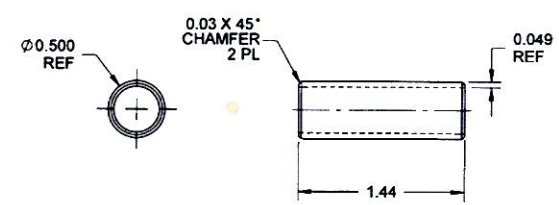
D3589-3 ARM GUIDE



D3589-23 ARM GUIDE



D3589-5 LATCH GUIDE



D3589-21 LATCH GUIDE

D3589-1/-3/-5/-21/-23 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING
 D3589-1: 0.375 O.D. X 0.065 WALL (REF. DART SPEC M304TR0.375W.065)
 D3589-3: 0.500 O.D. X 0.058 WALL (REF. DART SPEC M304TR0.500W.058)
 D3589-5/-21: 0.500 O.D. X 0.049 WALL (REF. DART SPEC M304TR0.500W.049)
 D3589-23: AISI 304/316 STAINLESS STEEL ROUND BAR PER ASTM A276 (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: - D3589-1 = 0.34 lbs
 - D3589-3 = 0.01 lbs
 - D3589-5 = 0.06 lbs
 - D3589-21 = 0.03 lbs
 - D3589-23 = 0.02 lbs

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 161642

170523

RELEASE
 2012-07-16

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3589	REV. C
MFG. APPR.		SHEET 4 OF 8	
APPROVED		TITLE	SCALE
DE APPR.		LATCH ASSEMBLY	NTS
DATE	12.07.04	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1